



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3884-1

Job Sheet 168595



Part No: D3884-1

Job Qty: 6 ea

Part Name: Saddle, Inside LH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/20/17

Job Tracking No:

Due Date: 11/22/17

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG REV C IPP RevA: New issue DD verified by: EC IPP REV: B 15.05.20 remove inside powdercoat DD
VERF: JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea	11/21/17	11/21/17	0.00	0.00	Start Up Machining		SBL 17/11/21
100	CNC Vertical Machining	6 pcs	11/21/17	11/21/17	0.50	10.91	HAAS 1		SBL 17/11/22
110	QC	6 pcs	11/21/17	11/21/17	0.00	0.00	QC2		SBL 17/11/22
120	QC	6 pcs	11/21/17	11/21/17	0.00	0.00	QC8		FK 17-11-23
130	HandFinish	6 pcs	11/21/17	11/21/17	0.00	0.34	HandFinish1		2017-11-24 JLM
140	Powdercoat	6 pcs	11/22/17	11/22/17	0.00	0.25	Powdercoat1		BL 17-11-29
150	QC	6 pcs	11/22/17	11/22/17	0.00	0.00	QC3		38
160	Packaging	6 pcs	11/22/17	11/22/17	0.00	0.00	Packaging3		DAS 9-86
170	QC21-SA	6 Ea	11/22/17	11/22/17	0.00	0.00	QC21		21 DEC 01 2017

Part Op 100 - Program Batch No. _____ 1-Machine Step No 1 per Folio FA818 and inspect per attached Dimension Sheets
Descriptions: 2-Machine Step No 2 per Folio FA818 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA818
and inspect per Dimension Sheets
110 - Inspect on CMM as per folio CMMA004.
140 - ***MASK INSIDE SURFACES OF SADDLE PRIOR TO APPLICATION OF POWDER COAT AS PER INDICATED
ON DWG (SEE NOTE 2)***

17138467 START: 9:25 O.V.T: 320 FINISH: 9:55.

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D6101-017	6	22	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Saddle, Inboard, LH	2.870Inches + 0.010 - 0.000	2.880 2.870		
2	Saddle, Inboard, LH	1.433Inches + 0.010 - 0.000	1.443 1.433		
3	Saddle, Inboard, LH	0.638Inches + 0.020 - 0.000	0.658 0.638		
4	Saddle, Inboard, LH	3.895Inches + 0.010 - 0.000	3.905 3.895		
5	Saddle, Inboard, LH	0.257Inches + 0.005 - 0.000	0.262 0.257		
6	Saddle, Inboard, LH	0.605Inches	0.625		

DART
AEROSPACE
S012129

Dart Aerospace Ltd.

1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



Saddle, Inside LH

PART NO: D3884-1

Revision:

Operation:

Change No:

Start up Operation

Mfg Date: 11/21/17

Job No: 168595

017 - (20) (11)
015 - (11)

			+ 0.020 - 0.000	0.605
7	Saddle, Inboard, LH	1.120Inches	+ 0.010 - 0.000	1.130 1.120
8	Saddle, Inboard, LH	2.245Inches	+ 0.010 - 0.000	2.255 2.245
9	Saddle, Inboard, LH	2.000Inches	+ 0.020 - 0.000	2.020 2.000
10	Saddle, Inboard, LH	0.140Inches	+ 0.035 - 0.000	0.175 0.140
11	Saddle, Inboard, LH	1.265Inches	+ 0.020 - 0.000	1.285 1.265
12	Saddle, Inboard, LH	0.115Inches	+ 0.020 - 0.000	0.135 0.115
13	Saddle, Inboard, LH	0.240Inches	+ 0.020 - 0.000	0.260 0.240
14	Saddle, Inboard, LH	0.110Inches	+ 0.030 - 0.000	0.140 0.110
15	Saddle, Inboard, LH	0.240Inches	+ 0.020 - 0.000	0.260 0.240
16	Saddle, Inboard, LH	2.826Inches	+ 0.060 - 0.000	2.886 2.826
17	Saddle, Inboard, LH	0.178Inches	+ 0.020 - 0.000	0.198 0.178
18	Saddle, Inboard, LH	0.140Inches	+ 0.025 - 0.000	0.165 0.140
19	Saddle, Inboard, LH	0.720Inches	+ 0.060 - 0.000	0.780 0.720
20	Saddle, Inboard, LH	1.220Inches	+ 0.060 - 0.000	1.280 1.220
21	Saddle, Inboard, LH	1.245Inches	+ 0.010 - 0.000	1.255 1.245
22	Saddle, Inboard, LH	5.990Inches	+ 0.020 - 0.000	6.010 5.990
23	Saddle, Inboard, LH	2.495Inches	+ 0.010 - 0.000	2.505 2.495
24	Saddle, Inboard, LH	0.490Inches	+ 0.020 - 0.000	0.510 0.490
25	Saddle, Inboard, LH	0.020Inches	+ 0.020 - 0.000	0.040 0.020
26	Saddle, Inboard, LH	0.313Inches	+ 0.005 - 0.000	0.318 0.313
27	Saddle, Inboard, LH	0.760Inches	+ 0.005 - 0.000	0.765 0.760
28	Saddle, Inboard, LH	0.215Inches	+ 0.005 - 0.000	0.220 0.215
29	Saddle, Inboard, LH	0.316Inches	+ 0.005 - 0.000	0.321 0.316
30	Saddle, Inboard, LH	1.745Inches	+ 0.010 - 0.000	1.755 1.745
31	Saddle, Inboard, LH	0.990Inches	+ 0.020 - 0.000	1.010 0.990

DART AEROSPACE LTD		Work Order: 168595	
Description: Saddle, Inboard, LH		Part Number: D3884-1	
Inspection Dwg: D3884 Rev. C		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	2.870	2.880		2,875	2,875	2,875	2,875	SBL	17/11/22
B	1.433	1.443		1,438	1,438	1,438	1,438	"	"
C	0.638	0.658		1,648	1,648	1,648	1,648	"	"
D	3.895	3.905		3,900	3,900	3,900	3,900	"	"
E	0.257	0.262		258	258	258	258	"	"
F	0.605	0.625		1,615	1,615	1,615	1,615	"	"
G	1.120	1.130		1,125	1,125	1,125	1,125	"	"
H	2.245	2.255		2,250	2,250	2,250	2,250	"	"
I	2.000	2.020		2,005	2,005	2,004	2,005	"	"
J	0.140	0.175		150	152	151	152	"	"
K	1.265	1.285		1,270	1,270	1,269	1,270	"	"
L	0.115	0.135		1,126	1,126	1,126	1,126	"	"
M	0.240	0.260		251	251	251	251	"	"
N	0.110	0.140		135	135	135	130	"	"
O	0.240	0.260		254	253	252	252	"	"
P	2.826	2.886		2,857	2,856	2,856	2,856	"	"
Q	0.178	0.198		188	188	188	188	"	"
R	0.140	0.165		150	152	151	151	"	"
S	0.720	0.780		760	760	760	760	"	"
T	1.220	1.280		1,250	1,250	1,250	1,250	"	"
U	1.245	1.255		1,250	1,250	1,250	1,250	"	"
V	5.990	6.010		6,000	6,000	6,001	6,001	"	"
W	2.495	2.505		2,500	2,500	2,500	2,500	"	"
X	0.490	0.510		500	500	500	500	"	"
Y	0.020	0.040		030	030	030	030	"	"
Z	0.313	0.318		313	313	313	313	"	"
AA	0.760	0.765		760	761	760	760	"	"
AB	0.215	0.220		216	217	217	217	"	"
AC	0.316	0.321		316	316	316	316	"	"
AD	1.745	1.755		1,750	1,750	1,750	1,750	"	"
AE	0.990	1.010		1,000	1,000	1,000	1,000	"	"
AF								"	"
Accept/Reject									

Measured by: SBL
Date: 17/11/22

Audited by: EK
Date: 17-11-23

Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	
B	15.09.09	Dwg Rev updated	KJ	

DART AEROSPACE LTD				Work Order: 168 595	
Description: Saddle, Inboard, LH				Part Number: D3884-1	
Inspection Dwg: D3884 Rev. C				Page 1 of 1	

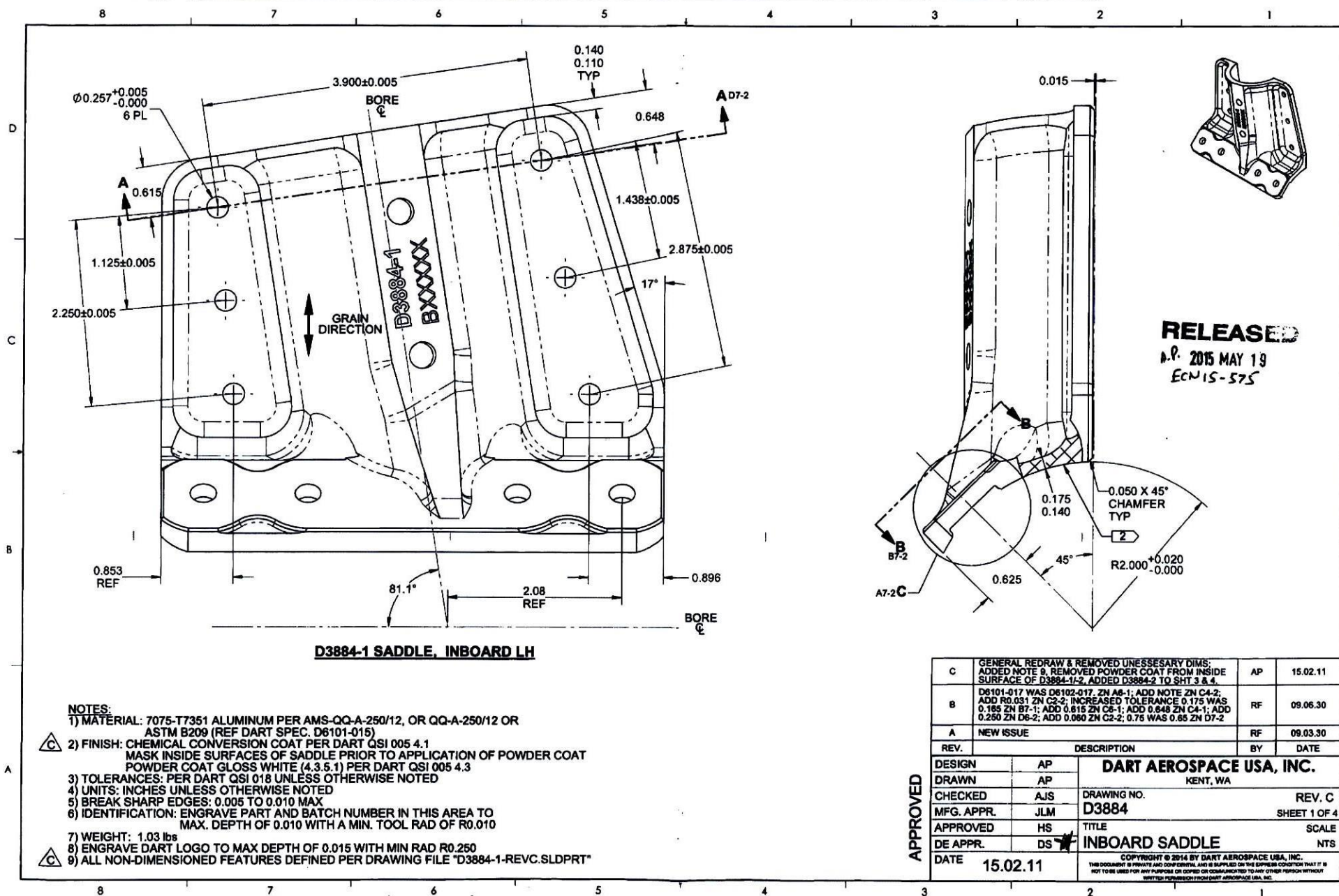
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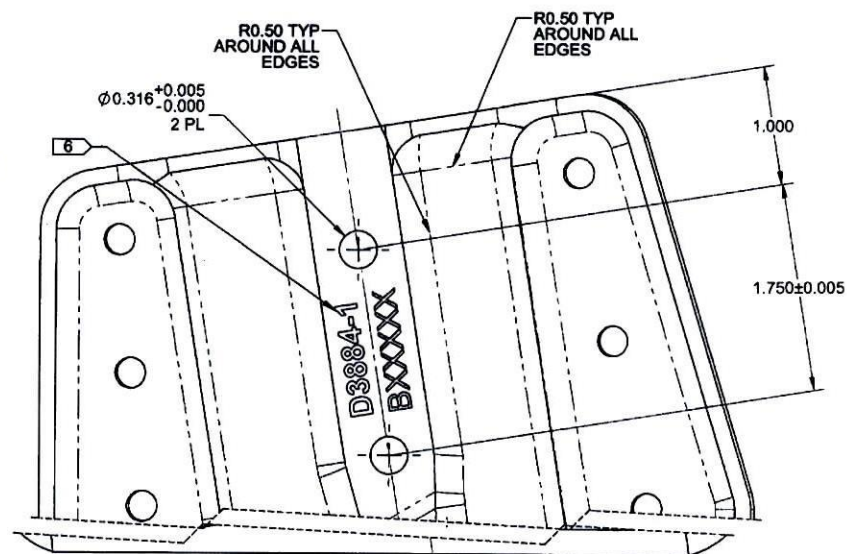
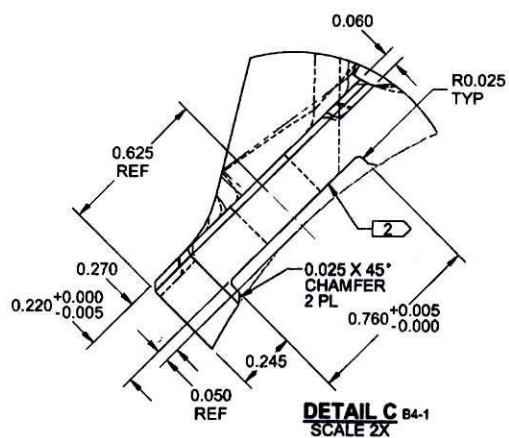
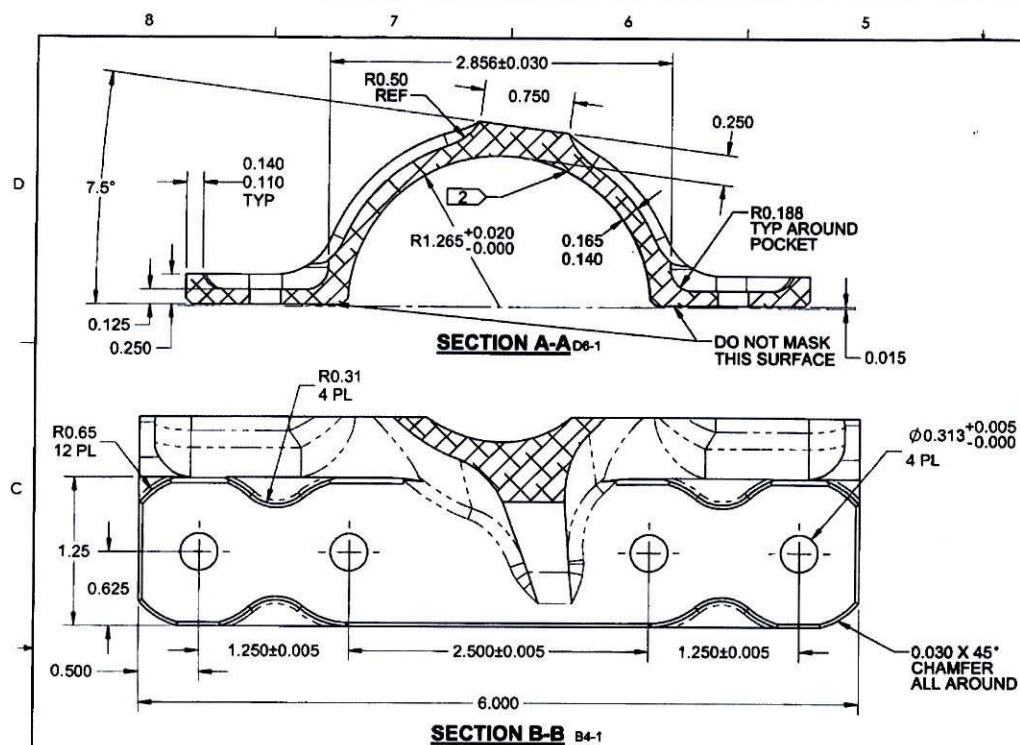
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				#5	#6	3	4		
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C	0.638	0.658		1.648	1.648				
D	3.895	3.905	3.900	3.900	3.90				
E	0.257	0.262		1.258	1.258				
F	0.605	0.625		1.615	1.615				
G	1.120	1.130	1.125	1.125	1.125				
H	2.245	2.255	2.250	2.250	2.250				
I	2.000	2.020		2.005	2.005				
J	0.140	0.175		1.151	1.151				
K	1.265	1.285		1.270	1.271				
L	0.115	0.135		1.127	1.126				
M	0.240	0.260		1.252	1.251				
N	0.110	0.140		1.140	1.135				
O	0.240	0.260		1.251	1.251				
P	2.826	2.886		2.856	2.856				
Q	0.178	0.198		1.188	1.188				
R	0.140	0.165		1.151	1.151				
S	0.720	0.780		1.760	1.760				
T	1.220	1.280		1.255	1.250				
U	1.245	1.255		1.250	1.250				
V	5.990	6.010		6.001	6.001				
W	2.495	2.505		2.500	2.500				
X	0.490	0.510		1.500	1.500				
Y	0.020	0.040		1.030	1.030				
Z	0.313	0.318		1.313	1.313				
AA	0.760	0.765		1.760	1.760				
AB	0.215	0.220		1.217	1.217				
AC	0.316	0.321		1.316	1.316				
AD	1.745	1.755		1.750	1.750				
AE	0.990	1.010		1.000	1.000				
AF									
Accept/Reject									

Measured by: SBL
Date: 17/11/22

Audited by: F.K.
Date: 17-11-23

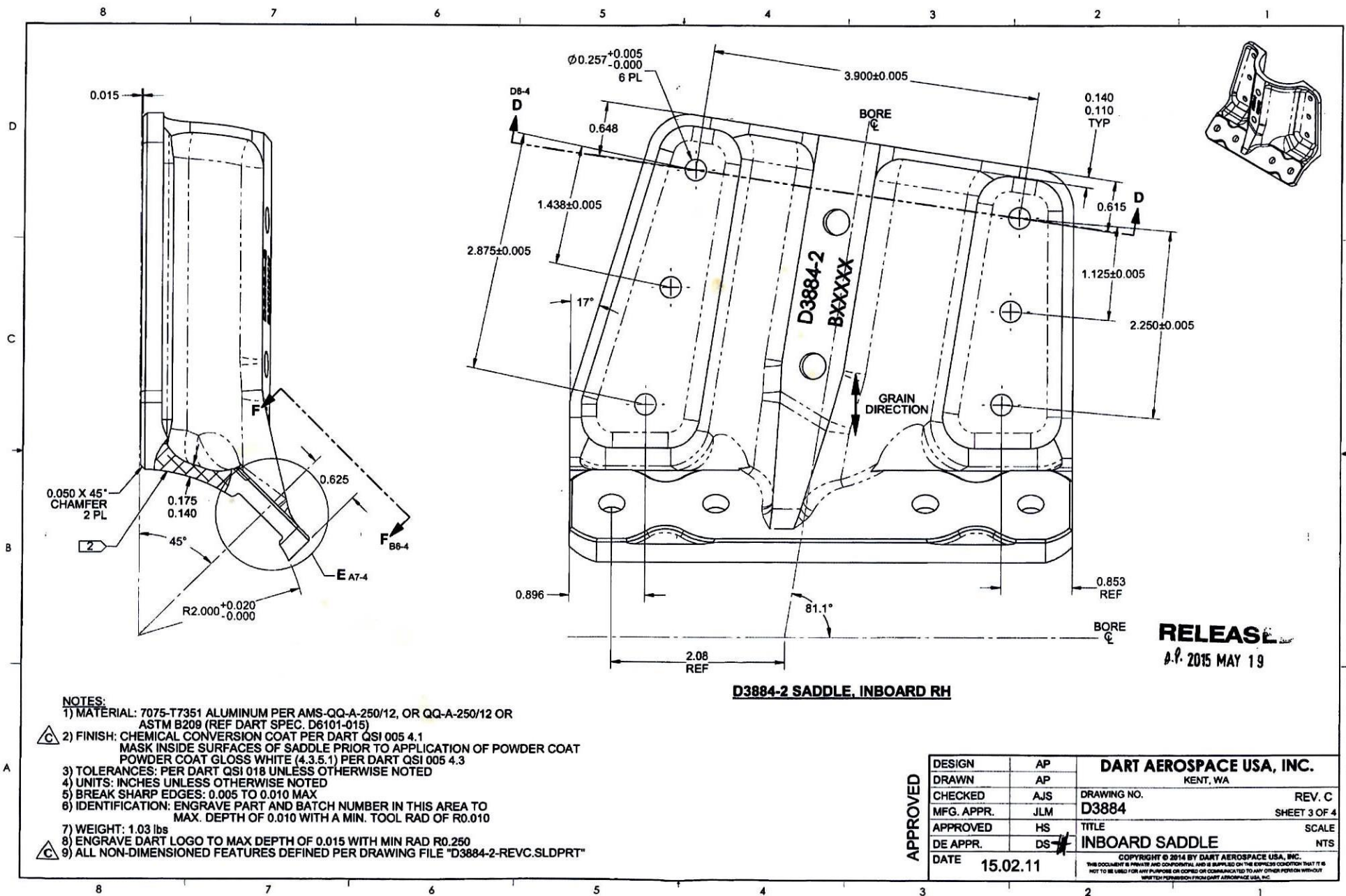
Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	
B	15.09.09	Dwg Rev updated	KJ	

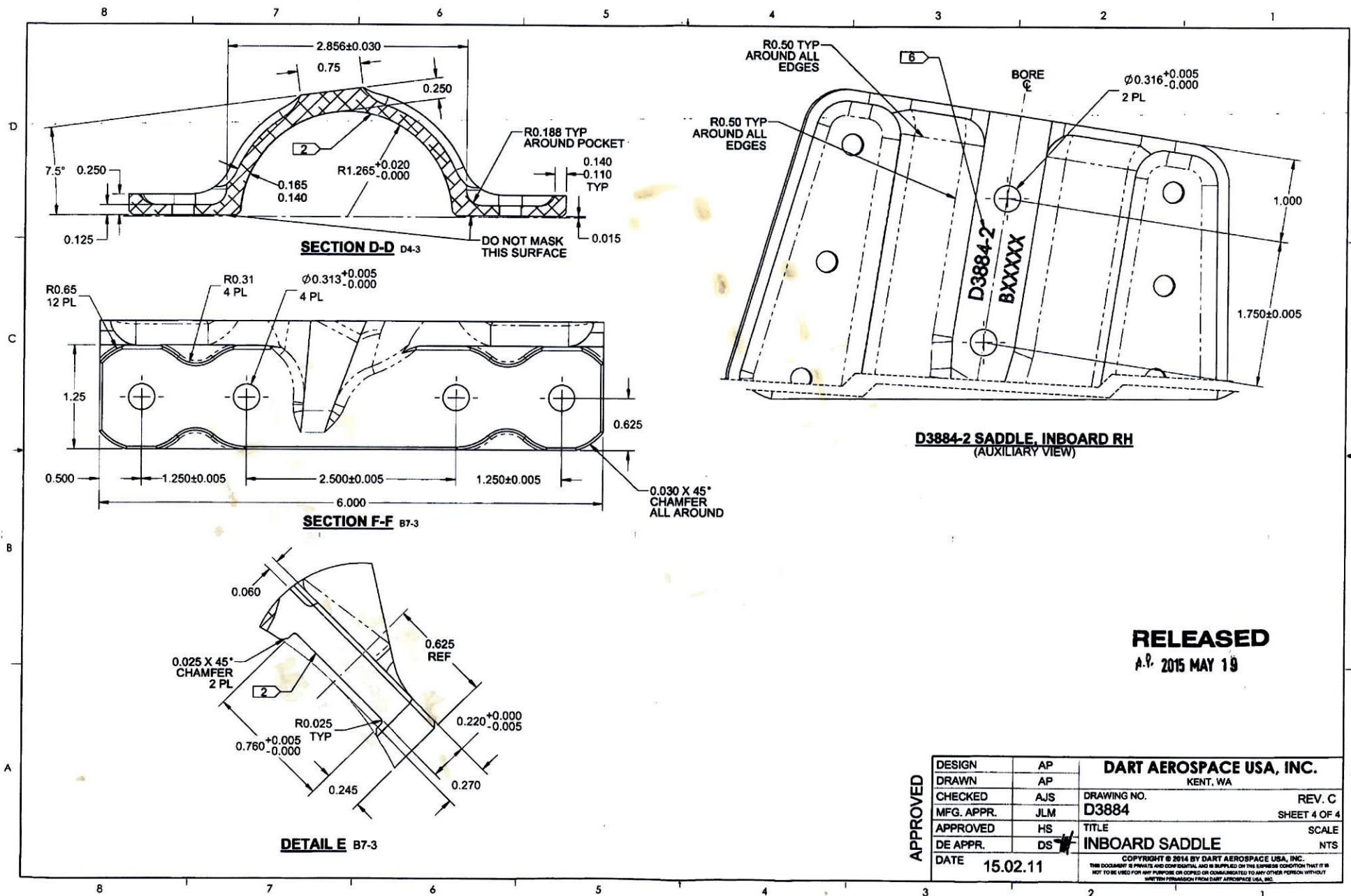




RELEASED
A-2 2015 MAY 19

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	DRAWN	AP	KENT, WA	
	CHECKED	AJS	DRAWING NO.	REV. C
	MFG. APPR.	JLM	D3884	SHEET 2 OF 4
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	INBOARD SADDLE	NTS
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